

Date: Thursday, 3/8/2007 1:14:52 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, LEFT SIDE
Job Number	: 31115		
Estimate Number	: 10833		
P.O. Number	: N/A	Part Number	: D29331
This Issue	: 3/8/2007	S.O. No. :	N/A
Prsht Rev.	: NC	Drawing Number	: D2933 UNDER REVIEW
First Issue	: N/A	Project Number	: N/A
Previous Run	: 30945	Drawing Revision	: EC CB 07.03.08
		Material	: N/A
		Due Date	: 3/30/2007
Written By	:	Qty:	3 Um: Each
Checked & Approved By	:		
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Issue material from stock: 7075-T7351 QQ-A-250/12

Cut Size 2.0 x 6.25 X 6.00

Grain Along Long 6.00 Length

Batch No: 17

325345 x 8

En 07/03/16

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number. En 07/03/20

1-Inspect part number and batch number are programmed correctly. SD 07.03.20

2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

5-Deburr

En 07/03/21

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

En 07/03/21

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

En 07/03/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					3		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PA Date: 07/03/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 1:14:52 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 31115

Part Number: D29331

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.03.21

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS 1 m.l

07-03-22 (8)

7.0

POWDER COATING

POWDER COATING



M103706



(8x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m.l

07/03/22

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/3/23 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/3/23 (8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/26

Job Completion



07-03-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31115
Description: 206 Saddle, Inboard, Left side	Part Number:	D2933-1
Inspection Dwg: D2933 Rev. <i>BC</i> <i>cb 07.03.08</i>		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.115	0.117	0.115	0.116		
B	0.100	0.140		0.124	0.121	0.124	0.121		
C	0.100	0.140		0.124	0.122	0.123	0.126		
D	0.210	0.230		0.223	0.220	0.223	0.223		
E	1.245	1.255		1.250	1.248	1.248	1.246		
F	1.245	1.255		1.250	1.248	1.248	1.246		
G	2.495	2.505		2.498	2.497	2.499	2.498		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.575	1.575	1.575	1.575		
J	2.495	2.505		2.502	2.500	2.499	2.498		
K	0.257	0.262		0.259	0.259	0.257	0.259		
L	0.312	0.317		0.315	0.315	0.315	0.315		
M	0.235	0.240		0.240	0.240	0.240	0.240		
N	0.100	0.140		not	on	the	Drawing		
O	0.540	0.560		0.543	0.544	0.543	0.543		
P	0.490	0.510		0.500	0.496	0.497	0.497		
Q	3.715	3.725		3.719	3.719	3.719	3.717		
R	2.470	2.510		2.495	2.494	2.500	2.498		
S	0.240	0.270		0.250	0.250	0.251	0.249		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.629	1.629	1.629	1.629		
V	1.362	1.372		1.366	1.368	1.364	1.364		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.135	1.134	1.135	1.136		
Y	1.565	1.585	DT8695 A/B						
Z	6.990	6.010		6.000	6.003	6.002	6.003		
AA	0.015	0.035		0.025	0.025	0.025	0.025		
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>En</i>
Date:	07/03/20

Audited by:	<i>SA</i>
Date:	07.03.21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	31115
Description: 206 Saddle, Inboard, Left side		Part Number:	D2933-1
Inspection Dwg: D2933 Rev. <i>BC</i> <i>CB 07.03.08</i>		Page 1 of 1	

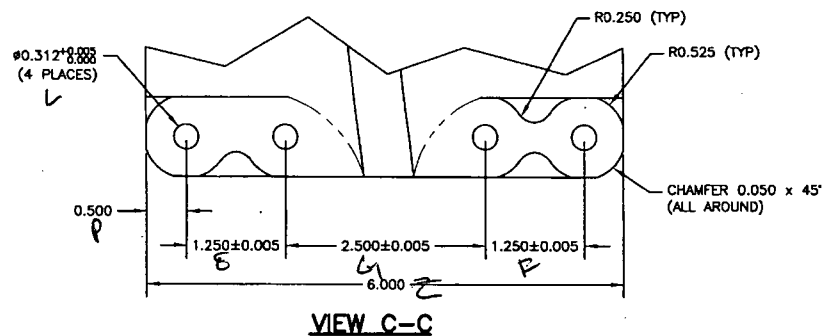
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.116	0.117	0.117	0.115		
B	0.100	0.140		0.123	0.123	0.126	0.121		
C	0.100	0.140		0.129	0.121	0.121	0.132		
D	0.210	0.230		0.220	0.219	0.222	0.220		
E	1.245	1.255		1.248	1.247	1.249	1.248		
F	1.245	1.255		1.248	1.247	1.249	1.248		
G	2.495	2.505		2.499	2.499	2.499	2.499		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.575	1.575	1.574		
J	2.495	2.505		2.498	2.496	2.496	2.498		
K	0.257	0.262		0.259	0.259	0.259	0.259		
L	0.312	0.317		0.315	0.315	0.315	0.315		
M	0.235	0.240		0.240	0.239	0.240	0.240		
N	0.100	0.140							
O	0.540	0.560		0.544	0.543	0.545	0.544		
P	0.490	0.510		0.499	0.499	0.500	0.498		
Q	3.715	3.725		3.717	3.717	3.719	3.719		
R	2.470	2.510		2.497	2.498	2.498	2.500		
S	0.240	0.270		0.251	0.250	0.251	0.253		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.626	1.626	1.627	1.627		
V	1.362	1.372		1.366	1.367	1.364	1.366		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.132	1.132	1.134	1.133		
Y	1.565	1.585	DT8695 A/B						
Z	5.990	6.010		6.002	6.004	6.002	6.000		
AA	0.015	0.035		0.025	0.025	0.025	0.025		
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>EP</i>
Date: <i>07/03/21</i>

Audited by: <i>SD</i>
Date: <i>07.03.21</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	<i>[Signature]</i>

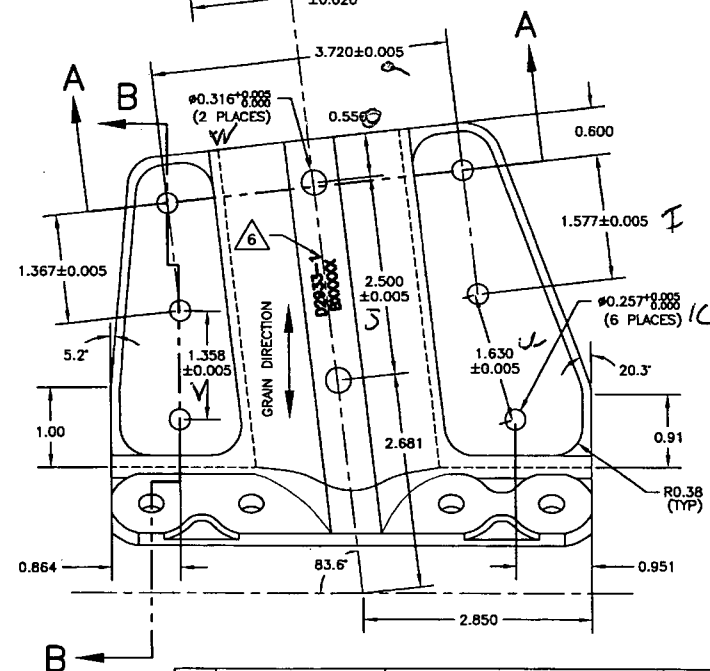
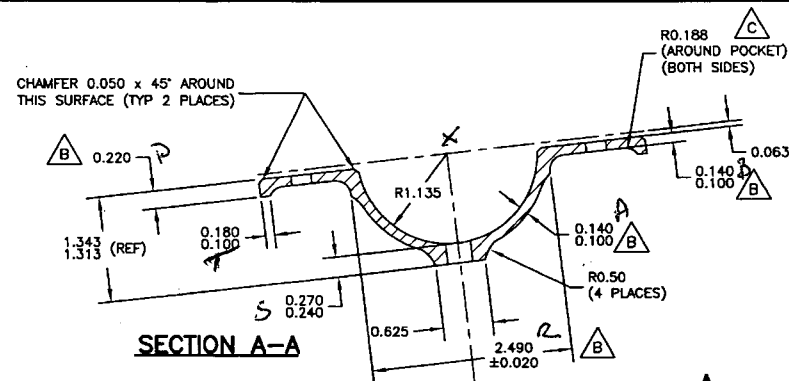
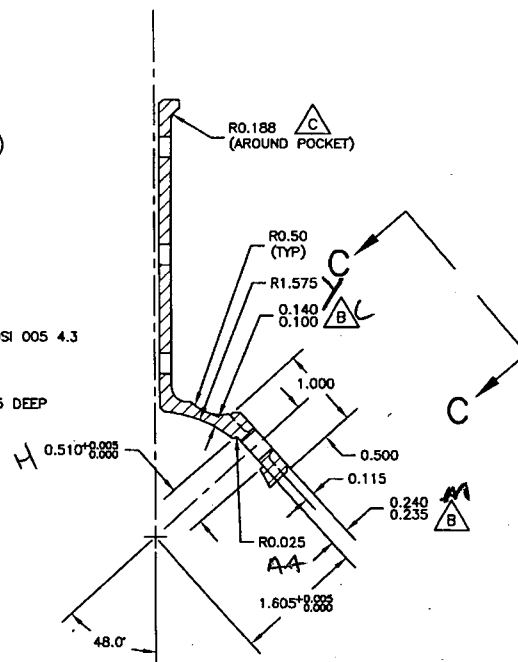


D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

NO. 31115
 WORK ORDER
 WITHOUT NOTICE
 UNCONTROLLED COPY
 ENGINEERING
 RETURN TO
 SHOP COPY

07.02.12 #



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	CB	DART AEROSPACE USA, INC.
CHECKED	PH	D2933
DATE	06.11.09	SADDLE INSIDE

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0.240
 + 0.030

